

Date: Tuesday, 04/07/2006 1:58:03 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP LEG
Job Number : 27756B	
Estimate Number : 10353	
P.O. Number : N/A	Part Number : D2278
This Issue : 04/07/2006 S.O. No. : N/A	Drawing Number : D2278 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : 28/06/2006 Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 25395B	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 12/07/2006
Checked & Approved By : _____	Qty: 40 Um: Each
Comment : Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now 6061-T6 06-06-23 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 1.0306 sf(s)/Unit Total : 41.2230 sf(s)
 Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick
 (M6061T62S.080)
 Identify as D2278
 Batch: 1101178

MM 06 07 12

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

MM 06 07 13 (40)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MM 06 07 13 (40)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

06-07-20 (40)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

SAD 06/07/27
M.F. 06/07/27 (40)

Date: Tuesday, 04/07/2006 1:58:04 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 27756B

Part Number: D2278

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF 06/07/27

(40)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 06:07:28

40

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SAD 06:07:31

40

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Doc 06/08/01

(40)

Job Completion



C206108/01

Date: Wednesday, 6/28/2006 4:18:31 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STEP LEG
Job Number :	27756B		
Estimate Number :	10353		
P.O. Number :		Part Number :	D2278
This Issue :	6/28/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2278 REV E
First Issue :	/ /	Project Number :	N/A
Previous Run :	25395B	Drawing Revision :	E
	Type :	Material :	
	SMALL / MED FAB	Due Date :	7/12/2006
Written By :	<i>[Signature]</i>	Qty:	40
Checked & Approved By :	<i>[Signature]</i>	Um:	Each
Comment :	Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now 6061-T6 06-06-23 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S080	6061-T6 .080 Sheet
-----	-------------	--------------------



Comment: Qty.: 1.0306 sf(s)/Unit Total: 41.2230 sf(s)
 Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick
 (M6061T62S.080)
 Identify as D2278
 Batch: *M101178*

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR
 Cut blanks: (16.61" x 8.51") +.000/-0.020" (grain along 8.51") for each leg

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1 Machine as per folio D2278, use stack of 10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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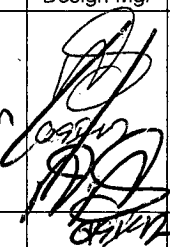

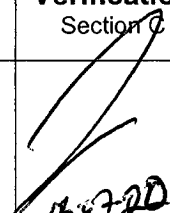
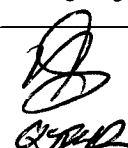
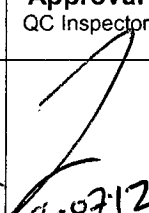
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 27756B		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
060712	2.0	6 prices cut with wrong grain direction		Destroy scrap prices and cut new ones	 060712	 060720	 060712	 060712

Part No: D2278

PAR # 1A

Fault Category: Prod / Machine

NCR: Yes

No

DQA: 

Date: 060810

NOTE: Date & initial all entries

QA: N/C Closed: 

Date: 06.08.03

Date: Wednesday, 6/28/2006 4:18:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 27756B

Part Number: D2278

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3-

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

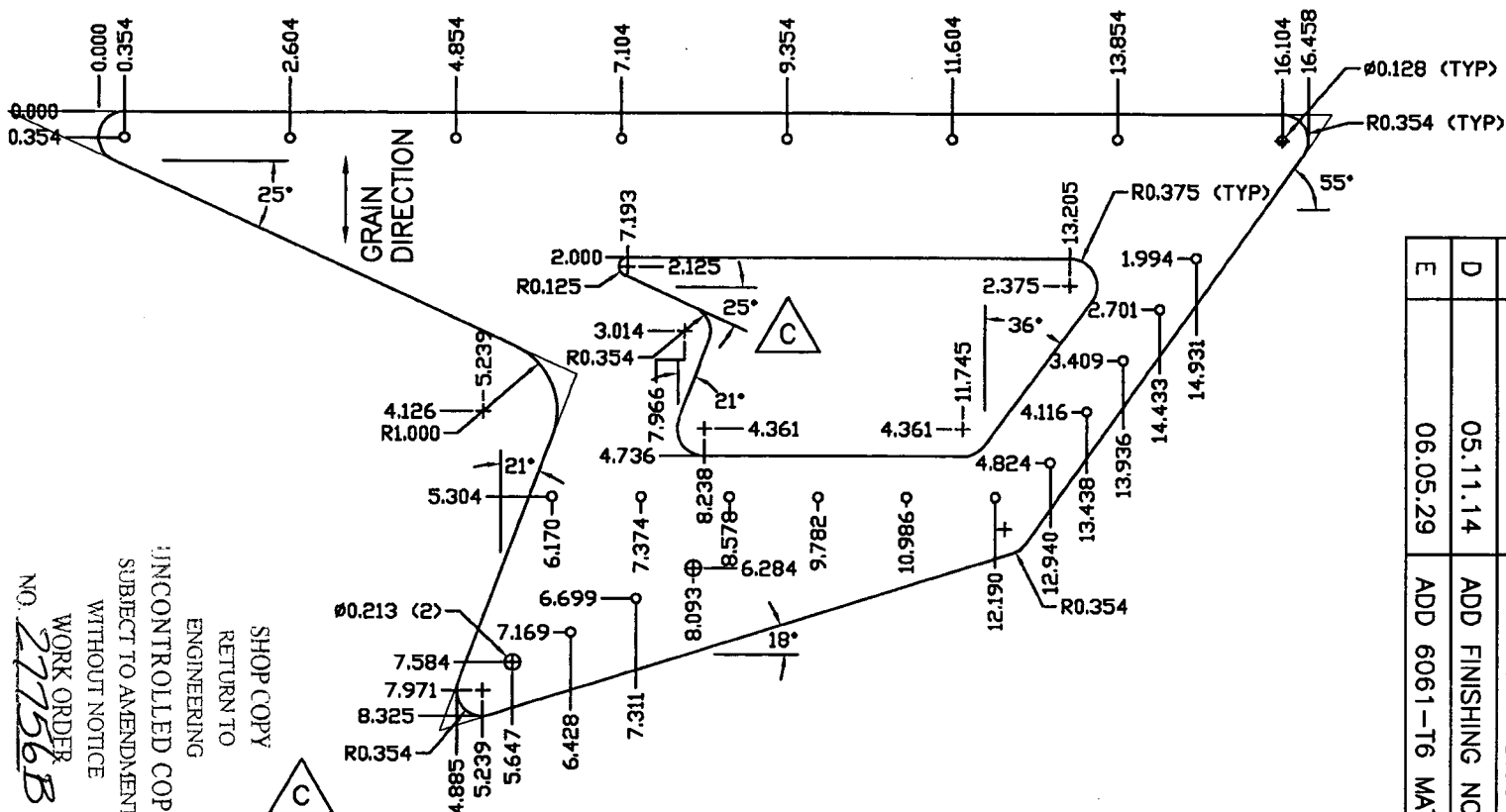
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
BW	CB	HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
PH		D2278	SHEET 1 OF 1
DATE	TITLE	SCALE	
06.05.29	LEG	1:2.5	
C	95.02.16	CHANGED RADIUS TO 0.354	
D	05.11.14	ADD FINISHING NOTE	
E	06.05.29	ADD 6061-T6 MATERIAL	

**D2278 LEG**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32 ALUMINUM SHEET (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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ENGINEERING

